Date:

Thursday, 08/03/2007 1:17:28 PM

User:

Linda Lacelle

Process Sheet

Customer Job Number **Estimate Number** P.O. Number This Issue

Prsht Rev.

First Issue

Written By

Comment

Previous Run

: CU-DAR001 Dart Helicopters Services : 31031B

: 10841 : NIA

: 08/03/2007

S.O. No. : NIA

: NC

: 07/03/2007

Type

: SMALL /MED FAB

Added Step 9 KJ/RF

Drawing Revision Material

Part Number

Drawing Number

Drawing Name

Due Date

: LUG

: D22493

D2249 REV. E

: N/A **Project Number**

: NIA

: 10/04/2007

Each

Additional Product

Checked & Approved By

Job Number:



: Est: D 05.02.04

Seq. #:

Description:

304/316 .063 Sheet

1.0

M304S16GA

Comment: Qty.:--0.1470 sf(s)/Unit Total: 1.4700 sf(s)

> 304/316 .063 Sheet Batch. M101463

2.0

WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D2249

Dwg Rev: E

m 07 03 14

QC2





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

3.0.

QC8

SECOND CHECK



Comment: SECOND CHECK



SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D2249



X/O

Thursday, 08/03/2007 1:17:28 PM Date: User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: LUG** Job Number: 31031B Part Number: D22493 Job Number: Seq. #: Description: **Machine Or Operation:** 6.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: QC21 8.0 Comment: FINAL INSPECTION/W/O RELEASE L 07.03.23 Job Completion

Qty:

10 Um:

Each

: LUG

: D22493

: 4/10/2007

: N/A

: E

: D2249 REV. E

Wednesday, 3/7/2007 8:38:08 AM

Kim Johnston

Process Sheet

Drawing Name

Part Number

Material **Due Date**

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Type

S.O. No. :

Job Number:

: 31031B

Estimate Number

: 10841

P.O. Number

This Issue

: 3/7/2007

: NC

First Issue : //

Previous Run

Written By

Prsht Rev.

Checked & Approved By

: Est: D 05.02.04 Added Step 9

: SMALL /MED FAB

KJ/RF

Comment **Additional Product**

Job Number:



Seq. #: ,

Machine Or Operation:

Description: PURCHASING

1:0**



Comment: PURCHASING

Issue P/O:

Email or ship DXF file to vendor Laser Cut D2249-3 as per Dwg D2249

Material release note required

2.0

D22493F



Comment: Qty.:

1.0000 U(s)/Unit

Total:

10,0000 U(s)

Base Plate

3.0

PACKAGING 1

BASE PLATE



Comment: PACKAGING RESOURCE #1

Recieive & Inspect for Transit Damage Ensure Material Release Note is attached

4.0

QC6

DIMENSIONAL CHECK

PACKAGING RESOURCE #1



Comment: DIMENSIONAL CHECK

Inspect dimensions as per template D2249-3T3 & Dwg D2249

5.0

LARGE FAB

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- Deburr any rough edges
- 2- Form D2249-3 using Jig D2249-3T4



Dart Ae	rospace Li	td					
W/O:		·	WORK ORDER O	HANGES		2.30	
DATE	STEP	PROCEDURE CHANGE		Ву	By Date Qty		Approval QC Inspector
Part No	:	PAR #:	Fault Category:	NCR: Yes	No DQA:	Date:	
				QA: N/	C Closed:	_ Date: _	
NCR:		WO	RK ORDER NON-CON	FORMANCE (NCR)	·	
· .		Description of NC	Corrective Action	Section B	Verification	Approval	Approval

NCR:		,	WORK ORDI	ER NON-CONFORMANO	CE (NCR)			
1.		Description of NC		Corrective Action Section B		Verification		Annroyal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Section		Approval Chief Eng	Approval QC Inspecto
						:		
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	-							
							İ	

NOTE: Date & initial all entries

Date:

Wednesday, 3/7/2007 8:38:08 AM

User:

+Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 31031B

Part Number: D22493

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Şir.

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

8:0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No		PAR #· Fault Category:	NCR: Yes	No DO	١.	Date:			

QA: N/C Closed: ____ Date: ____

NCR:		,						
		Description of NC		Corrective Action Section B		Verification	Annroval	Annroyal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries



99.09.20

FITTING

NEW ISSUE

TITLE

D2249 DRAWING NO.

SHEET 1 OF 4 SCALE NTS

DART

RT AEROSPACE L

94.10.12

 \circ $\boldsymbol{\omega}$ \triangleright

95.12.14 95.11.30 94.06.20

DIMENSION CHANGE

DIMENSION CHANGE

O

98.04.30

Ø0.261 WAS Ø0.257 REMOVED DUPLICATE

(TSR A179)
DIMENSIONS

99.09.20

ADDED GUSSET

D2249	-5 (2) - 0.800 - D2249-3 (1) -5 (2) - 1.600 - C
D2249-1 (2)	2.00 WELD USING TOOL DT8209
	D2249-041 ASSEMBLY 14/316 SS, 0.063 THICK QSI 004 COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 ARE IN INCHES PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

D2249-5 (REF)

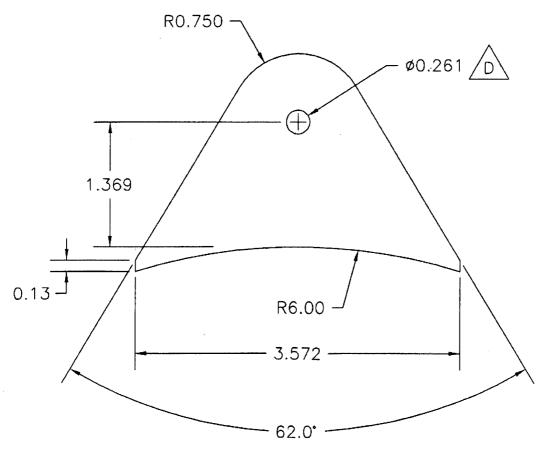
WORK ORDER





DESIGN KE	DRAWN BY		ROSPACE LTD , ontario, canada
CHECKED	APPROYED	D2249	REV. E SHEET 2 OF 4
DATE	1 //	TITLE	SCALE SCALE
99.09.20		FITTING	. 1:1





D2249-1 LUG

SHOP COPY

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ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

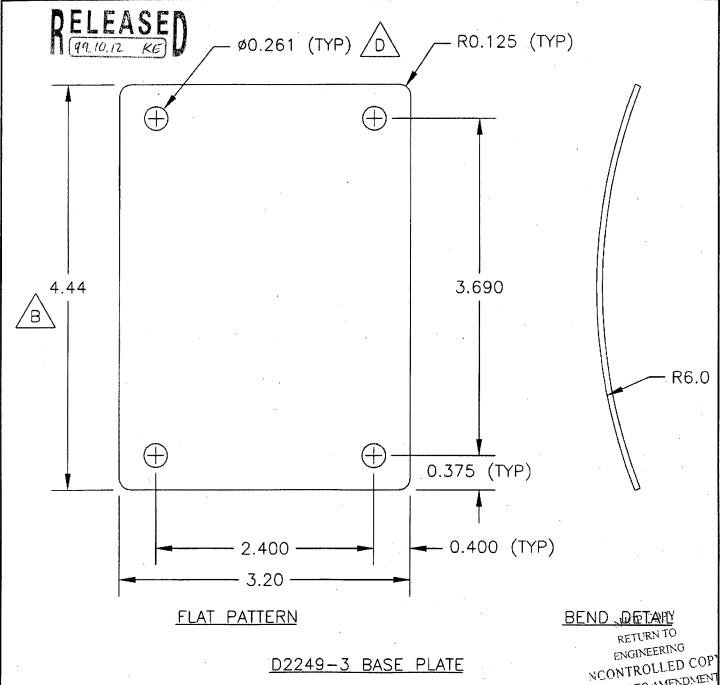
WITHOUT NOTICE

WORK ORDER

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY RF	1	ROSPACE LTD y, ontario, canada
CHECKED	APPROYED	DRAWING NO.	REV. E
ME	#	D2249	SHEET 3 OF 4
DATE		TITLE	SCALE
99.09.20		FITTING	1.1



D2249-3 BASE PLATE

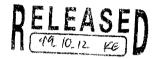
MATERIAL: AISI 304/316 SS 0.063 THICK ALL DIMENSIONS ARE IN INCHES

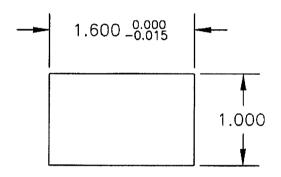
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





DESIGN	ORAWN BY		AEROSPACE LTD ESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE		TITLE	SCALE
99.09.20		FITTING	1:1





D2249-5 GUSSET

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART AEROSPACE LTD	Work Order:	31031B
Description: Lug	Part Number:	D2249-3
Inspection Dwg: D2249 Rev: 6		Page 1 of 1

FIRST, ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
\$0.261	10.006-0.001	0.261	J		vern	
4.44	+1-0.010	4.445	1		vern	
3.690	+1-0.010	3.691			Vern	
2,400	+1-0.010	2.397	/		vern	
3.20	+1-0.030	3.201	√		verni	
0.375	+1-0.010	0.378	V		vern	
0.400	+1-0.010	0.400	/		VerN	
						•

					4
Measured by:	ml.ml	Audited by:		Prototype Approval:	$\Lambda \Omega \Lambda$
Date:		Date:	0703.14	Date:	10//+
			0 10 4 . 1		

Rev	Date	Change	Revised by	Approved
1100	Duto	New Issue	KJ/JLM	

